

Work Order ID 105290

August-01-13 11:22:35 AM

105290

Page 1

Item ID: D412-709-013

Revision ID:

Item Name: Escape Panel Push-Out Window Clear Fits LH Or RH

Start Date: 8/01/13 Start Qty: 2.00 *2*

Required Date: 8/01/13 Req'd Qty: 2.00 *2*

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: MCS Date: 13-08-01

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo <u>M.D.</u>	0.00							
Document Control	Photocopy bluefile & type labels per PPD412-709-013		CHG001						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
06
9-89
APR 11 2014

2x

MCS 14-04-11
②

2x

DAS
28
9-89

APR 11 2014

DAS
31
9-89

DAS
06
9-89

APR 11 2014

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions
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☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 105290

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105290

Page 2

Item ID: D412-709-013

Revision ID:

Item Name: Escape Panel Push-Out Window Clear Fits LH Or RH

Start Date: 8/01/13 Start Qty: 2.00 *2*

Required Date: 8/01/13 Req'd Qty: 2.00 *2*

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-709-013

Location: _____

PPP Rev: _____

0.00

0.00

0.00

0.00

DAS
06
9-89

APR 11 2014

Ship

2

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

MLJ 14-04-11

YMF
14-4-11

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Operator ☐									
Material ☐									
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Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions
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Picklist Print

August-01-13 11:22:35 AM

Page 1

Work Order ID: 105290

Parent Item: D412-709-013

Parent Item Name: Escape Panel Push-Out Window Clear Fits LH Or RH

Start Date: 8/01/13

Required Date: 8/01/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-05-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3136-043 Window Assembly	DAS 06 9-89	Manufactured	No			110	Each	0.0000	1			DAS 28 9-89	
D3237-1 Seal Retainer(price per sq ft)	DAS 06 9-89	Manufactured	No			110	f	25.0000	8.1666	17.192842		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST404		25							
				32825		25							
D3237-3 Seal Filler(price per sq ft)	DAS 06 9-89	Manufactured	No			110	f	157.5784	8.166	17.191579		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST407		157.5784315							
				60149		157.578431							
D3561-1 Seal Insert Tool	DAS 06 9-89	Manufactured	No			110	Each	10.0000	1	2		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST058		10							
				100592		10							

2x98" cut (1) at 98" per kit

2x98" cut (1) at 98" per kit

2x

APR 14 2014

DAS 31 9-89

DAS 31 9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

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APR 11 2014

DART AEROSPACE LTD.

REFERENCE ONLY

DAS
06
9-89

IIN-D412-709

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-709-011	ESCAPE PANEL MODIFICATION KIT
1	X						D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		X					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
		1	X				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				X			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					X		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	X	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			1				D2126-0720	LOCKING SEAL
1							D3118-3	SIGN ASSEMBLY
				1			D3136-041	WINDOW ASSEMBLY
							D3136-043	WINDOW ASSEMBLY
1							D3224-1	FRAME
			1				D3236-1	WINDOW
						1	D3237-1-0720	SEAL RETAINER
				1			D3237-1-0980	SEAL RETAINER
						1	D3237-3-0720	SEAL FILLER
				1			D3237-3-0980	SEAL FILLER
2							D3239-1	COVER
		1					D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
				1		1	D3561-1	WINDOW SEAL TOOL
3							AN6-20A	BOLT
2							AN960JD10L	WASHER
5							AN960JD616	WASHER
5							AN960JD616L	WASHER
2							MS21042L3	NUT
3							MS21042L6	NUT
2							MS35207-262	SCREW

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Revision: C

Date: 06.11.27